

Work Order ID 76854

76854

Page 1

November-22-11 10:54:39 AM

Item ID: D119-675-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step LH
 Start Date: 22/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 06/12/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/11/22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
N/A	Rev N/A

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP 119-675011 CHG003								

004 *[Signature]* for MLJ 11-12-21 (4)

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

SP 11-12-21

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

11-12-22 (4)

76852

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76854

November-22-11 10:54:39 AM

76854

Page 2

Item ID: D119-675-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step LH

Stop ***NS2***

Start Date: 22/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 06/12/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-675-011 Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

SP 11-12-22

11/12/22

MF
11-12-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-22-11 10:54:42 AM

Page 1

Work Order ID: 76854

76854

Parent Item: D119-675-011

D119-675-011

Parent Item Name: Heli-Access-Step LH

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D Removed Manufacturing JLM 05-11-01
IPP RevE change at rev.b as per ECN1107 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3043-041 *D3043-041* Step Weldment LH, A119		Manufactured	No			110	Each	0.0000	1	4			
D2182B032 *D2182B032* Rubber Cushion		Manufactured	No			120	Each	24.0000	4	16			
ST402 KIT @ 3.2" /													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST402		24							
				63469		4							
				73932		20							
D2274 *D2274* Radius Block		Manufactured	No			120	Each	463.0000	8	32			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST010		250							
				72121		16							
				73389		234							
				ST139		213							
				74435		213							

ST402
63469
73932
ST010
72121
73389
ST139
74435

**

**

**

76852

80

16

B76104 SP.
32

WHL
x4

WHL
x4

WHL
x4

ST402 KIT @ 3.2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-22-11 10:54:42 AM

Work Order ID: 76854

76854

Parent Item: D119-675-011

D119-675-011

Parent Item Name: Heli-Access-Step LH

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 4.00

Required Qty: 4.00

D2617-3
D2617-3
Bushing

Manufactured No

120 Each

26.0000

4 16

**

SP

B76948 10x

Location	Loc Qty	Loc Code
FG	10	
27991	10	
ST019	6	
68254	6	
ST020	10	
76818	10	

* 6x

D2617-5
D2617-5
Spacer

Manufactured No

120 Each

38.0000

8 32

**

B77502 SP

Location	Loc Qty	Loc Code
FG	10	
31756	10	
ST019	28	
73710	28	

D2732
D2732
Rubber Extrusion
79 per lot @ 32x

Manufactured No

120 f

402.9200

1.066 4.264

**

B 70987 SP

Location	Loc Qty	Loc Code
ST410	402.92	
70987	402.92	

D3041-1
D3041-1
Clamp

Manufactured No

120 Each

20.0000

4 16

**

SP 11-12-22

* B77050 12x

Location	Loc Qty	Loc Code
ST462	20	
67778	20	

4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-22-11 10:54:42 AM

Page 3

Work Order ID: 76854

76854

Parent Item: D119-675-011

D119-675-011

Parent Item Name: Heli-Access-Step LH

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 4.00

Required Qty: 4.00

Manufactured No 120 Each 8.0000

2

8

**

B76181 SP
4X B76097

D3041-3
D3041-3

Clamp

Location

Loc Qty

Loc Code

ST462

8

51114

8

Manufactured No 120 Each 15.0000

4

16

**

B77487 SP
11-12-22

D3042-1
D3042-1

Clamp

Location

Loc Qty

Loc Code

ST457

15

67402

15

Purchased No 120 Each 248.0000

4

16

**

SP

AN4-11A
AN4-11A

Bolt

Location

Loc Qty

Loc Code

ST356

248

110382

1

115316

47

117872

100

118706

100

Purchased No 120 Each 178.0000

8

32

**

SP 11-12-21

AN4-12A
AN4-12A

Bolt

Location

Loc Qty

Loc Code

ST357

178

115422

4

117508

74

118628

100

22X
10X

November-22-11 10:54:43 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-22-11 10:54:43 AM

Page 4

Work Order ID: 76854

76854

Parent Item: D119-675-011

D119-675-011

Parent Item Name: Heli-Access-Step LH

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-15A
AN4-15A
Bolt

Purchased

No

120

Each

295.0000

4 16

**

M119862.SP
16X

Location

Loc Qty

Loc Code

ST358

295

118112

4

118648

63

118706

19

119127

9

119449

200

AN960JD416

NAS1149D0463J

Purchased

No

120

Each

0.0000

12 48

**

M119075

AN960JD416

Washer

MS21042L4

Purchased

No

120

Each

11,294.00

12 48

**

SP11-12-21

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

552

117441

51

117601

368

118451

133

ST516

5742

119017

5742

ST518

5000

119075

5000

48X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE:

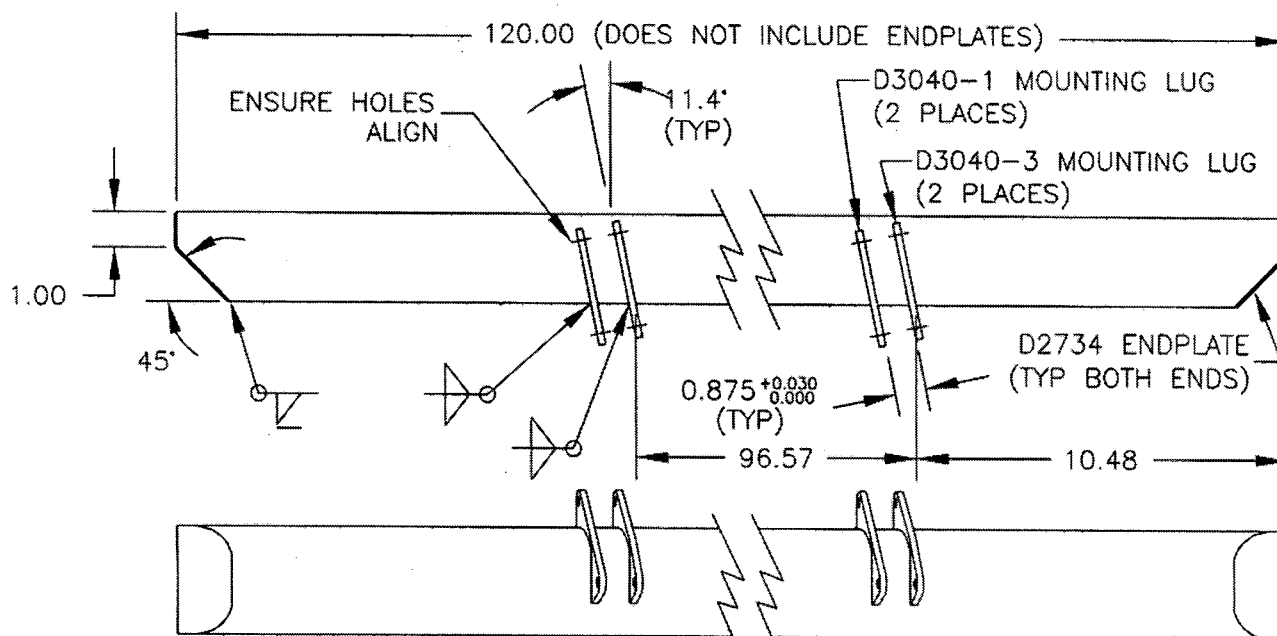
Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-675-011 <i>HELI-ACCESS-STEP™, LH</i>	11.5 lb 5.2 kg	- 32.4 in - 1.28 m	- 373 in-lb - 6.7 m-kg	121.3 in 3.08 m	1395 in-lb 16.0 m-kg
D119-675-012 <i>HELI-ACCESS-STEP™, RH</i>	11.5 lb 5.2 kg	+32.4 in +1.28 m	+373 in-lb +6.7 m-kg	121.3 in 3.08 m	1395 in-lb 16.0 m-kg

5.0 PARTS LIST:

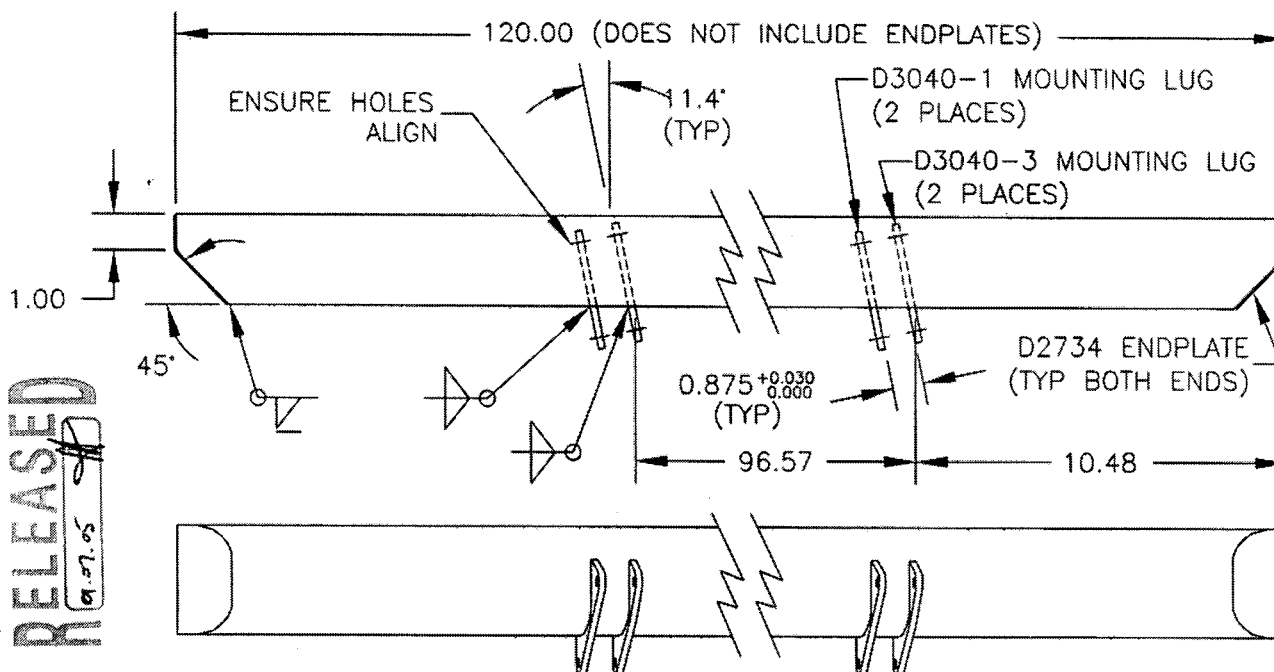
Qty -011	Qty -012	Part Number	Description
X		D119-675-011	<i>HELI-ACCESS-STEP™, LH</i>
	X	D119-675-012	<i>HELI-ACCESS-STEP™, RH</i>
4	4	D2182B032	RUBBER CUSHION
8	8	D2274	RADIUS BLOCK
4	4	D2617-3	BUSHING
8	8	D2617-5	BUSHING
4	4	D2732-032	RUBBER CUSHION
4	4	D3041-1	CLAMP
2	2	D3041-3	CLAMP
4	4	D3042-1	CLAMP
1		D3043-041	STEP WELDMENT LH
	1	D3043-042	STEP WELDMENT RH
4	4	AN4-15A	BOLT
4	4	AN4-11A	BOLT
8	8	AN4-12A	BOLT
12	12	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)



DESIGN CP	DRAWN BY CP	REFERENCE ONLY DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

RELEASED
01.07.05

Copyright © 2001 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Part Number D119-675-011 / 1012 Change Record
Description A119 H21 - ACCESS - STEP

Page 1 of 11. Action-Performance Report

3